

**Work Order ID 89934**

September-13-12 8:28:19 AM

\*89934\*

Page 1

**Item ID:** D412-742-043

## Accept

\*N900040100\*

## Setup Start

\*NS1\*

**Revision ID:**

**Item Name:** Replacement Float Skidtube

**Start Date:** 9/13/12      **Start Qty:** 1.00

\*1\*

**Cust Item ID:**

**Required Date:** 10/12/12      **Req'd Qty:** 1.00

\*1\*

**Customer:**

## **Reference:**

Approvals: Process Plan: M13

Date: 12/09/13 Tooling:

Date:

### Run Start

\*NR1\*

86

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date:

\*NR2\*

Work Order ID 89934

\*89934\*

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September-13-12 8:28:19 AM

Item ID: D412-742-043

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Replacement Float Skidtube

Start Date: 9/13/12 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 10/12/12 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID  
110

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

\*110\*

HandFinishing

0.00

1x

-d

SL u/u/z0

HandFinish

Memo

0.00

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex  
241/291. Ensure tube ends line-up with saddle holes for proper alignment. using  
7/16" "T" Pins.

A/RSikaflex-241/291 M112302

Expiry date: 13103

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against  
wearplate, then topped with the SS washer. Seal all bolts with sikaflex except  
ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/RSikaflex-241/291 M112302

Expiry date: 13103

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with  
MEK degreaser.

A/RLPS Procyon M1114596

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**Item ID:** D412-742-043

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

**Revision ID:**

**Item Name:** Replacement Float Skidtube

Stop

**\*NS2\***

**Start Date:** 9/13/12    **Start Qty:** 1.00

**\*1\***

**Cust Item ID:**

**Required Date:** 10/12/12    **Req'd Qty:** 1.00

**\*1\***

**Customer:**

**Reference:**

**Approvals:** Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

**Sequence ID/  
Work Center ID**

**Operation  
Description**

**Set Up/  
Run Hours**

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

120

**\*120\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

(DAS  
16  
0.52) 12/11/12

130

**\*130\***

Packaging

Packaging

0.00

PPP90700

(DAS  
20  
0.52)

12/11/12

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-742-043

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

140

**\*140\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

12/11/12

ME  
12-11-25



# Picklist Print

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Page 2

**Work Order ID:** 89934

**Parent Item:** D412-742-043

**Parent Item Name:** Replacement Float Skidtube

**Start Date:** 9/13/12

**Required Date:** 10/12/12

**Start Qty:** 1.00

**Required Qty:** 1.00

AN3C6A  
BOLT

Purchased	No	110	Each	1,139.0000	10	SL 10	12/11/20
-----------	----	-----	------	------------	----	-------	----------

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	1	
111982	1	
ST351	1138	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	3	
120693	42	
121682	4	
122416	500	
122599	500	

AN3C7A  
BOLT

Purchased	No	110	Each	218.0000	4	SL 4	12/11/20
-----------	----	-----	------	----------	---	------	----------

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	218	
113149	14	
116169	1	
117313	10	
117619	12	
117688	6	
119749	1	
120731	8	
121185	14	
121541	2	
122141	100	
122800	50	

# Picklist Print

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Page 3

**Work Order ID:** 89934

**Parent Item:** D412-742-043

**Parent Item Name:** Replacement Float Skidtube

**Start Date:** 9/13/12

**Required Date:** 10/12/12

AN960C10L  
washer

NAS1149C0332R Purchased

No

110

Each

21.0000

38

HL 38

111120

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST	21	M1123355
		21	x38

D4095-041  
Wearplate Assembly

Manufactured No

110 Each

29.0000

1 HL 1

111120

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP001	23	
	83809	7	
	85616	4	
	85844	12	X1
	FP002	6	
	85939	6	

D4095-043  
Wearplate Assembly

Manufactured No

110 Each

22.0000

1 HL 1

111120

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP001	22	B92345
	83479	7	X1
	85615	3	
	85843	12	

D4095-045  
Wearplate Assembly

Manufactured No

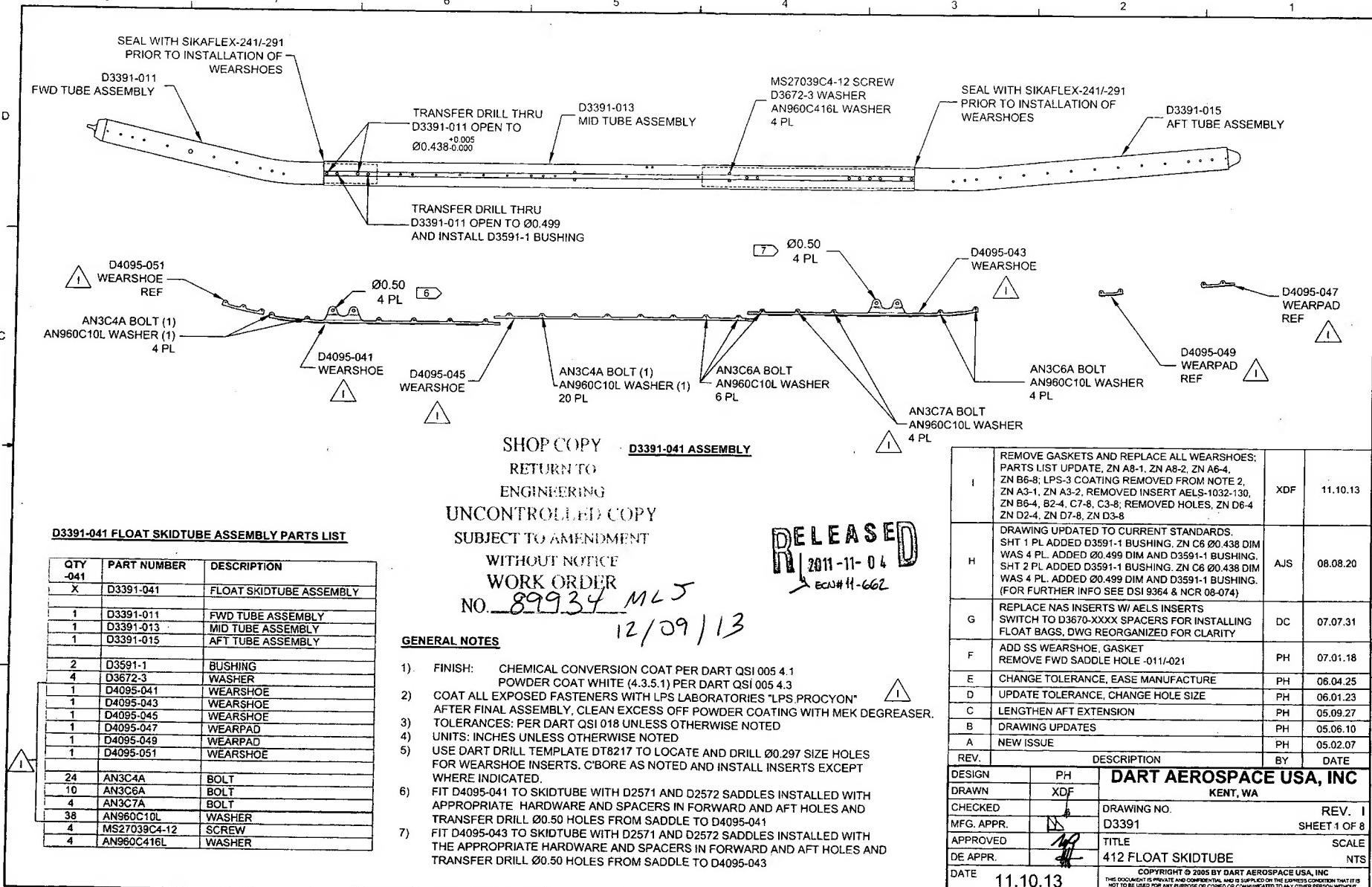
110 Each

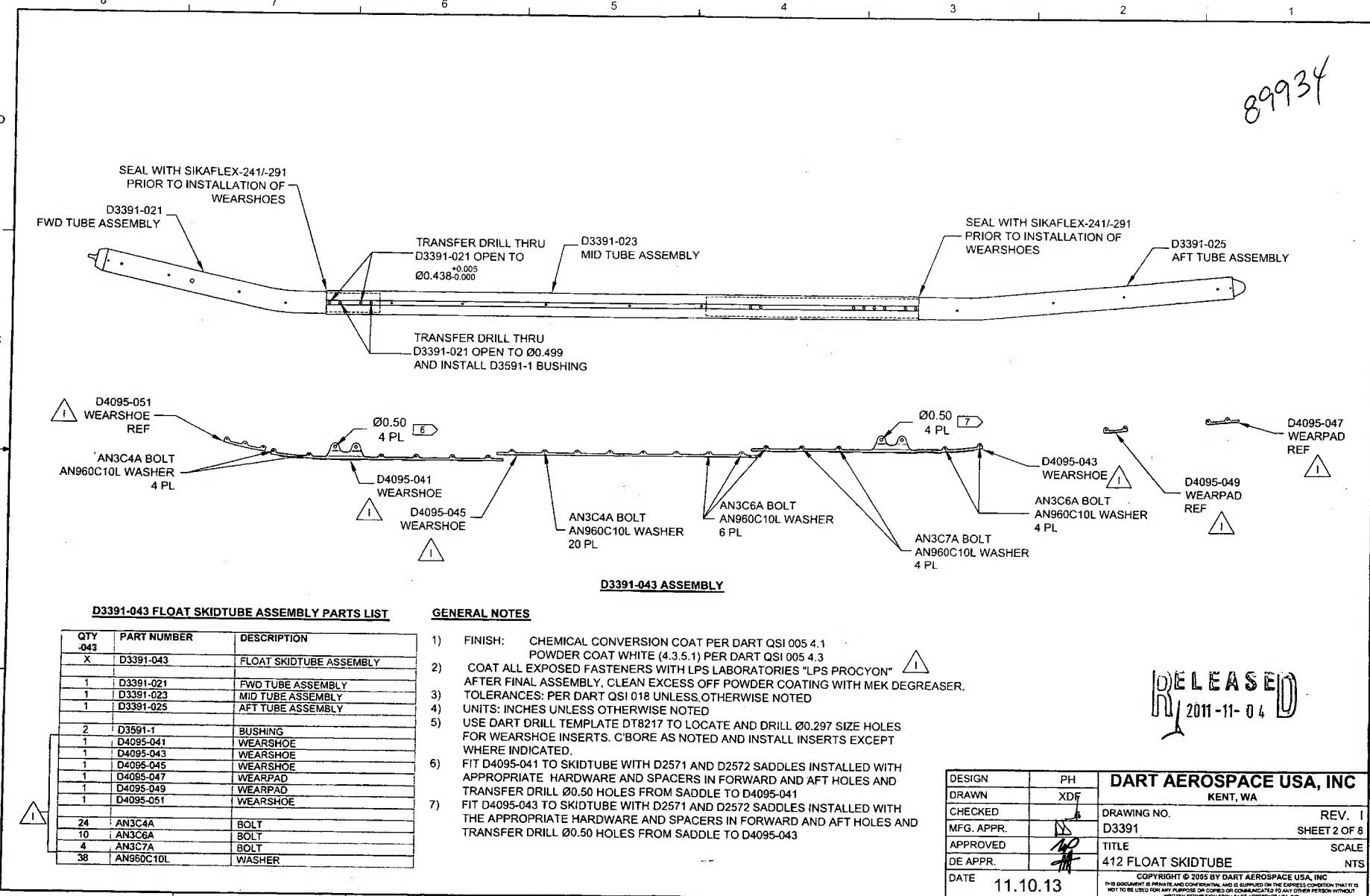
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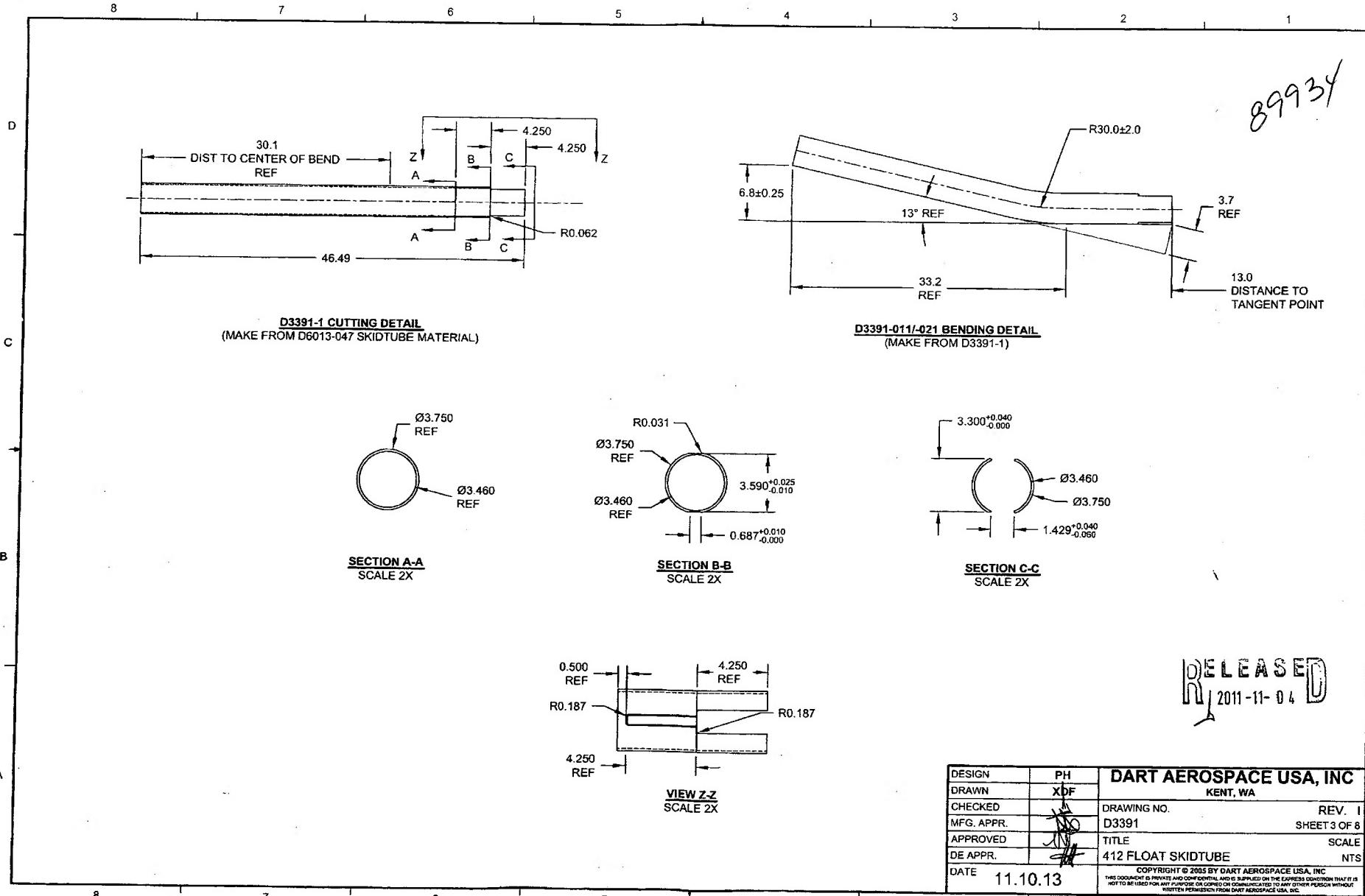
1 HL 1 u 1120

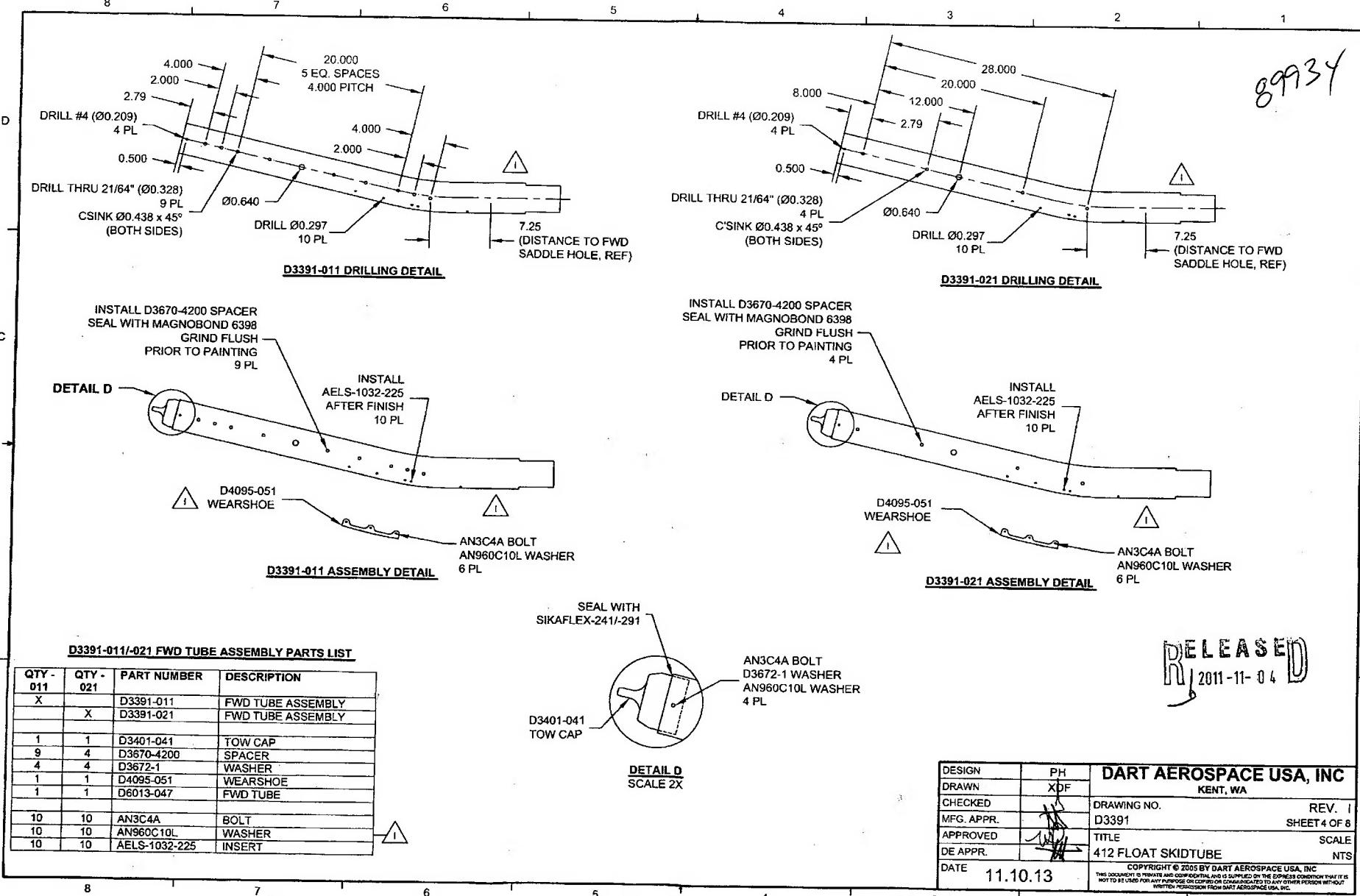
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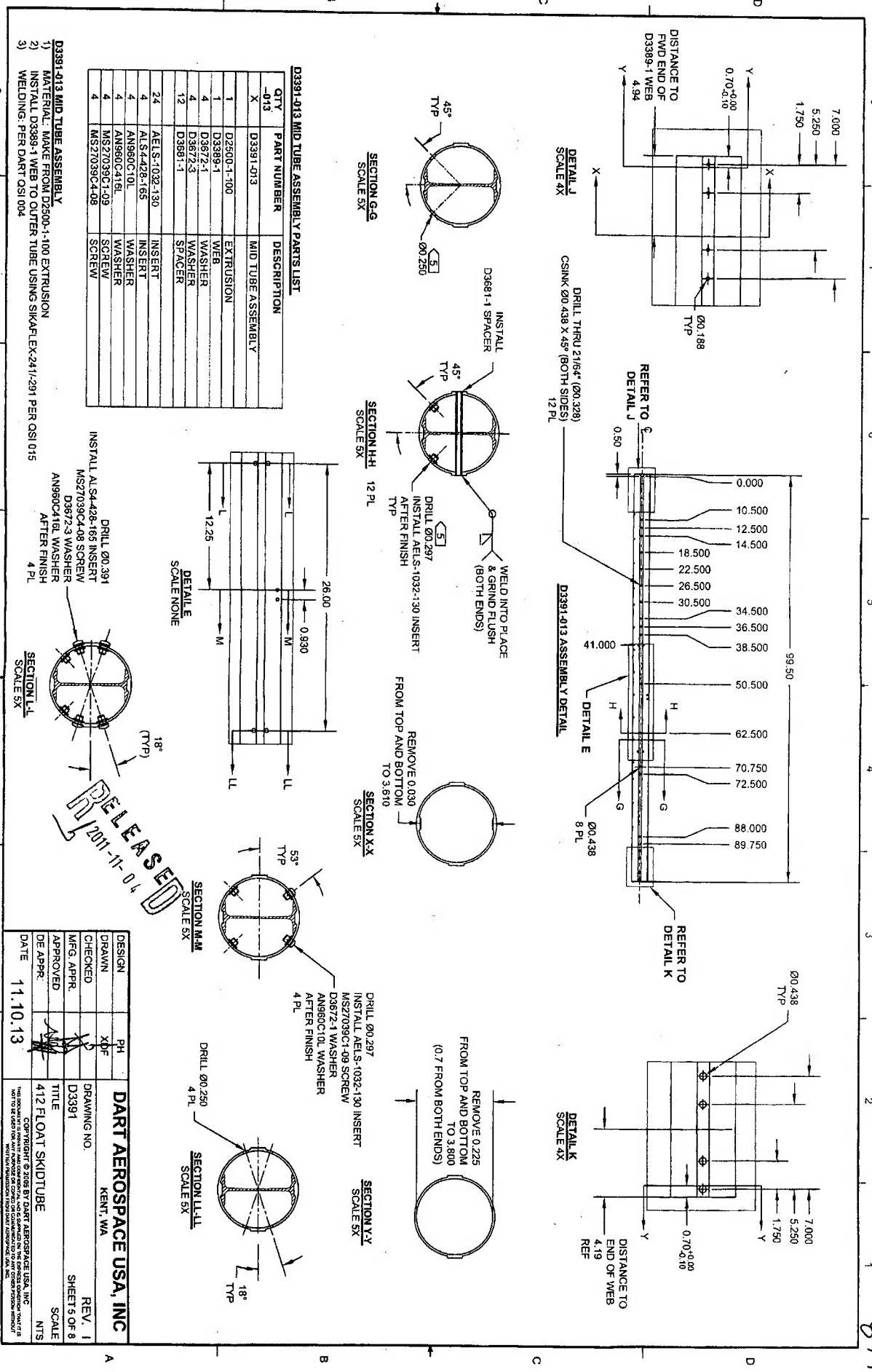
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	FP001	21	
	77737	1	
	84081	3	
	85614	7	
	86244	10	X1









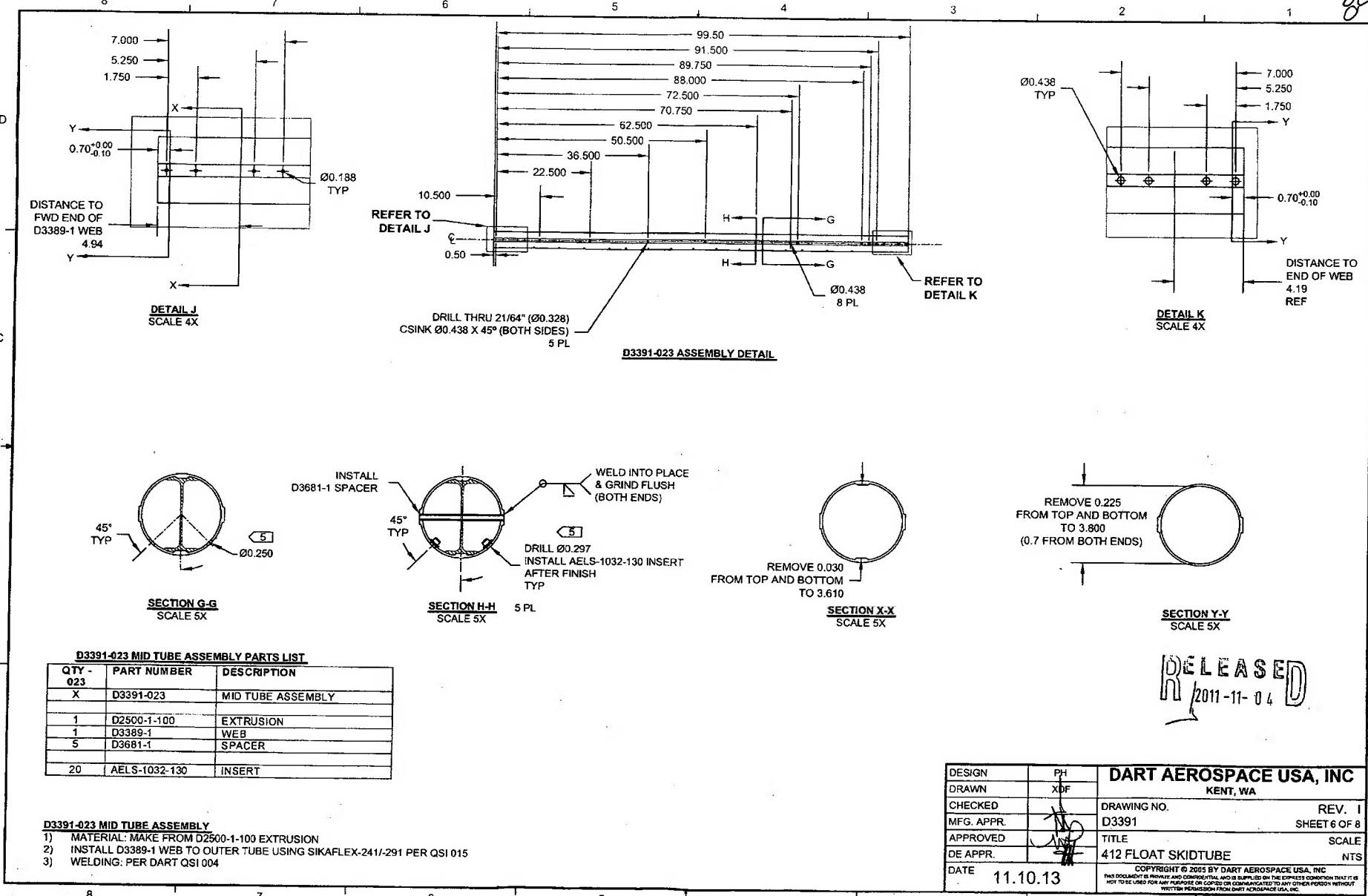


**D3391-013 MID TUBE ASSEMBLY**

DSI 015

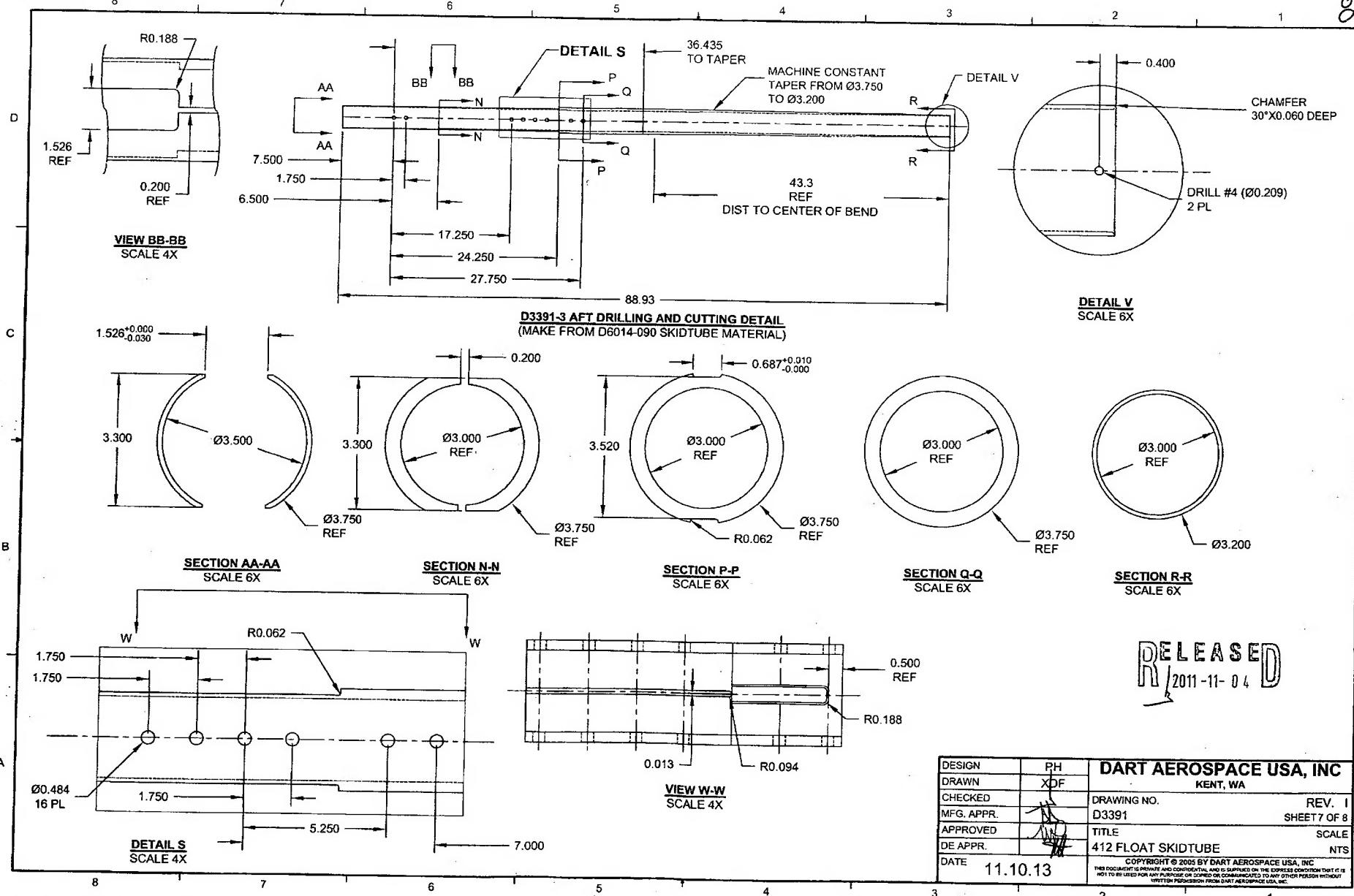
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**412 FLOAT SKIDTUBE** NTS  
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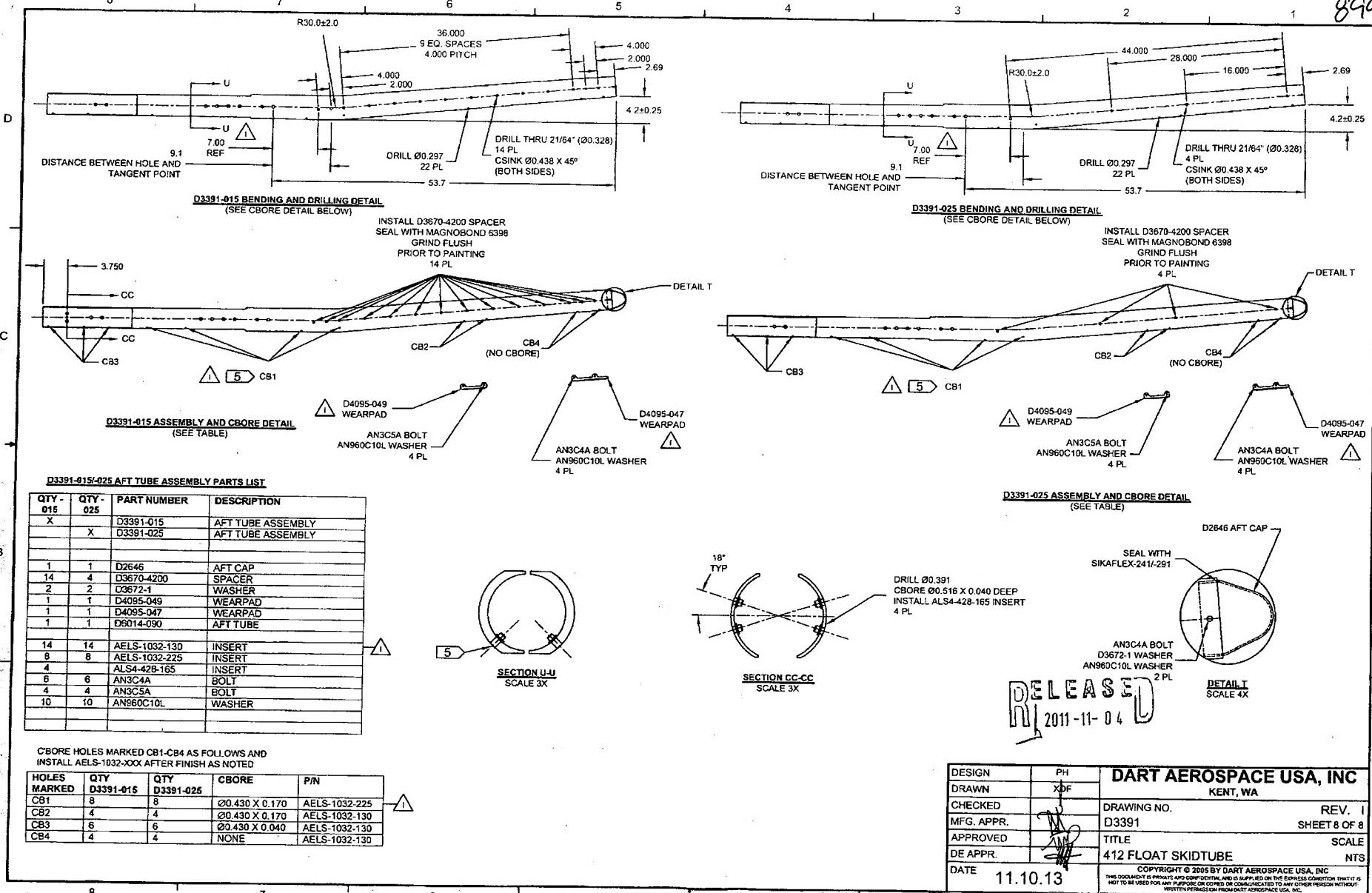
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89934





89934

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2011-11-0

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